

Work Order ID 120670

June-10-14 9:15:33 AM

120670

Page 1

Item ID: D4434-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Bracket

Stop *NS2*

Start Date: 6/10/14 Start Qty: 10.00

10

Cust Item ID:

Required Date: 6/10/14 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: *u* Date: Tooling: Date:

Run Start *NR1*

QC: Date: SPC (Y/N): Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4434	C

100 0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut D4434-1 as per Dwg

Dwg Rev: *C*

Prog Rev: *C*

2-Deburr if necessary

 10 *mm* *14/06/10*

110 0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

 10 *mm* *14/06/10*

Work Order ID 120670

June-10-14 9:15:33 AM

120670

Page 2

Item ID: D4434-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Bracket

Start Date: 6/10/14

Start Qty: 10.00

10

Cust Item ID:

Required Date: 6/10/14

Req'd Qty: 10.00

10

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Stop

NR2

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

EB
14/6/11

DAS
27
9-89

120

QC

Memo

0.00

(10)
count

Quality Control

130

Bend as per dwg

0.00

DAS
30
9-89

130

Brake NC

Memo

0.00

10

14/6/11
36
9-89

Brake NC

1-C'sink as per dwg.

150

QC5- Inspect part completeness to step on W/O

0.00

DAS
27
9-89

150

QC

Memo

0.00

10

Quality Control

14/6/12

Work Order ID 120670

June-10-14 9:15:33 AM

120670

Page 3

Item ID: D4434-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Bracket

Start Date: 6/10/14

Start Qty: 10.00

10

Cust Item ID:

Required Date: 6/10/14

Req'd Qty: 10.00

10

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Chemical Conversion Coat per QSI005 4.1

0.00

160

HandFinish

Memo

0.00

Hand Finishing

10

DMC 14-06-12

170

QC7-Inspect Chemical Conversion Coat

0.00

170

QC

Memo

0.00

Quality Control

DAS
30
9-89

60

14/6/12

180

Identify as per dwg & Stock Location: G.A.

0.00

180

Packaging

Memo

0.00

Packaging

20

FF 14-07-09

Work Order ID 120670

120670

Page 4

June-10-14 9:15:33 AM

Item ID: D4434-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Bracket

Start Date: 6/10/14 Start Qty: 10.00

10

Cust Item ID:

Required Date: 6/10/14 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
100									
QC	Memo	0.00							
Quality Control									

MLJ 140709

4-7-9

Picklist Print

June-10-14 9:15:33 AM

Page 1

Work Order ID: 120670

120670

Parent Item: D4434-1

D4434-1

Parent Item Name: Bracket

Start Date: 6/10/14

Required Date: 6/10/14

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A 13.04.01 AS PER D4434 REV.C DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6S.040

Purchased

No

sf

294.5200

17

M6061T6S 040

mm 17/06/14

6061-T6 .040 Sheet

Location

Loc Qty

Loc Code

MAT021

294.52

m126350

19.52

m126981

76.91

m128422

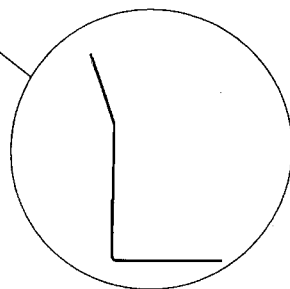
49.79

m129165

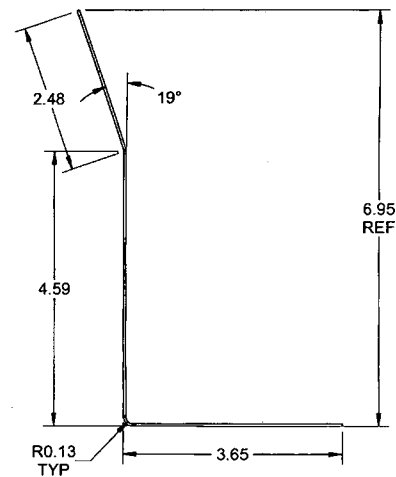
148.3

18.3

B
B2-6



4.55



D4434-1 BRACKET

W/O 120670

DETAIL B C8-6
SCALE 2X

RELEASED
2014-03-31

NOTES:

- 1) MATERIAL: MAKE FROM D4434-1F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.70 lbs

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	DC	DRAWING NO. D4434	REV. C
MFG. APPR.	DD		SHEET 6 OF 15
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	COVER ASSEMBLY	NTS
DATE	14.03.06	COPYRIGHT © 2012 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

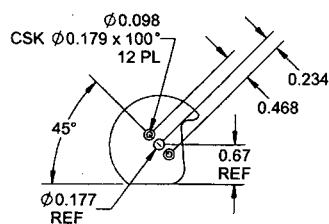
8 7 6 5 4 3 2 1

D

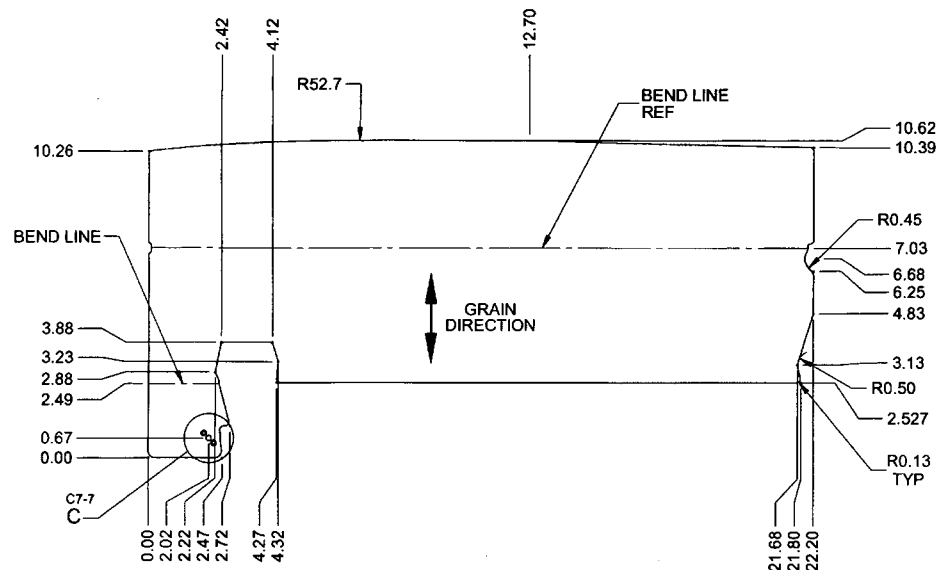
C

B

A



DETAIL C
SCALE 2X



D4434-1F FLAT PATTERN

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.040 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC. M6061T6S.040
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.70 lbs

RELEASED
2014-03-31

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	DC	DRAWING NO.	REV. C
MFG. APPR.	DD	D4434	SHEET 7 OF 15
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	COVER ASSEMBLY	NTS
DATE	14.03.06	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1